



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3910-3

Job Sheet 192861



Part No: D3910-3

Job Qty: 30 pcs

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/3/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E SHEETS 1,3 IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP REV:C 18.02.02 REMOVE FINISH DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
110	Purchasing	30 pcs	4/19/19	4/19/19	0.00	0.00	Purchasing - 1 Purchasing - 2 Purchasing - 3	APR 23 2019
120	Packaging 2-1 - Receive - B4B	30 pcs	4/19/19	4/19/19	0.00	0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B Packaging 2 - 5 - B4B Packaging 2 - 4 - B4B Packaging 2 - 6 - B4B Packaging 2 - 7 - B4B Packaging 2 - 8 - B4B Packaging 2 - 9 - B4B Packaging 2 - 10 - B4B Packaging 2 - 11 - B4B Packaging 2 - 12 - B4B Packaging 2 - 13 - B4B Packaging 2 - 14 - B4B Packaging 2 - 15 - B4B Packaging 2 - 16 - B4B Packaging 2 - 17 - B4B Packaging 2 - 18 - B4B Packaging 2 - 19 - B4B Packaging 2 - 20 - B4B Packaging 2 - 21 - B4B Packaging 2 - 22 - B4B Packaging 2 - 23 - B4B Packaging 2 - 24 - B4B Packaging 2 - 25 - B4B Packaging 2 - 26 - B4B Packaging 2 - 27 - B4B	APR 23 2019



Container No: S174245



Part: D3910-3

Job No: 192861

Serial No/Batch: S174245

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/23/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
130	QC 6	30 pcs	4/19/19	0.00 0.00	QC 6 - 9	APR 23 2019 DAS 40
					QC 6 - 68	9-89
					QC 6 - 61	
180	Packaging 3-1 - Stock - B4B	30 pcs	4/19/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	30 pcs	4/19/19	0.00 0.00	QC 21 - SA - 21	DAS 21 APR 23 2019
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 110 - (Purchasing) ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005
 Descriptions: 120 - (Receive & Inspect for Damage & Mat'l Certs) Ensure C of C is attach
 130 - (QC6- All purchased or subcontracted products)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

PO 043091 plus x 15 APR 03 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	3.7500 ft (.125 ea)	110-Purchasing	5174244
D3910-3P	Crosstube Lug	30 pcs (1 ea)	110-Purchasing	5174239

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	4	420	0
	D3910-3P	30	0	0

Part Specifications

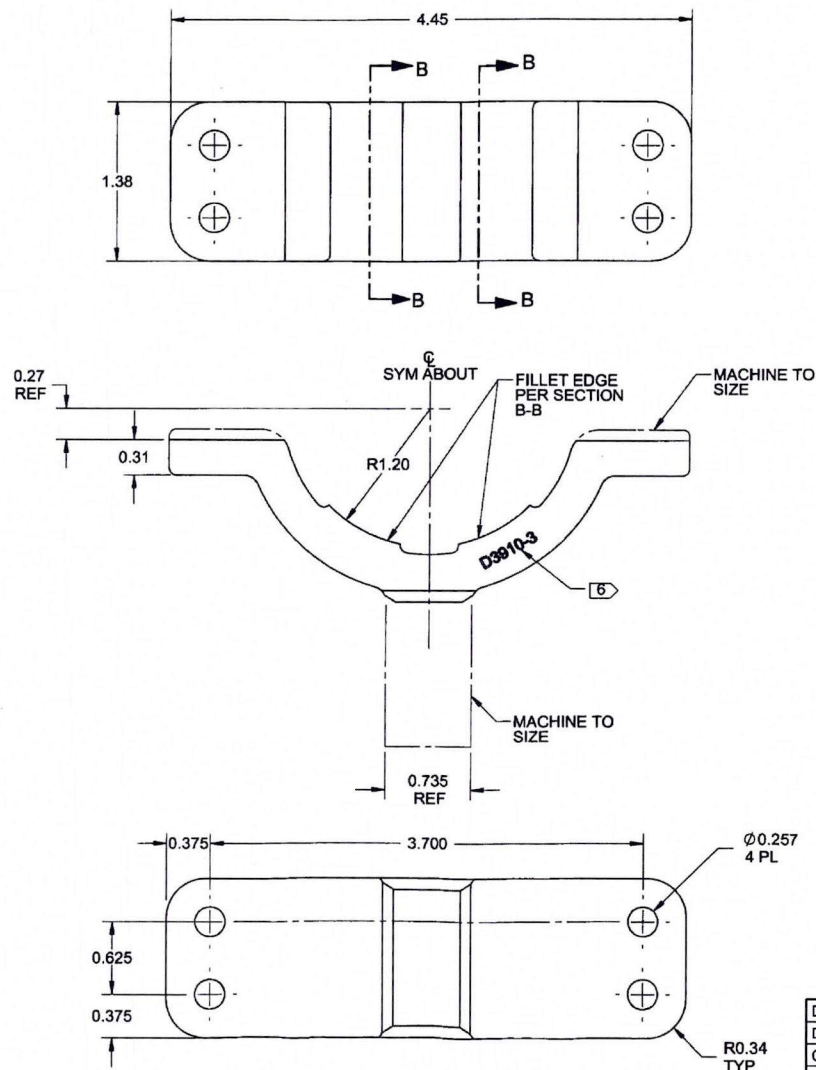
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches $\pm$ 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches $\pm$ 0.030	1.410 1.350		
3	Crosstube Lug	0.080Inches $\pm$ 0.020	0.100 0.060	Radius	
4	Crosstube Lug	0.270Inches $\pm$ 0.030	0.300 0.240	reference	
5	Crosstube Lug	0.310Inches $\pm$ 0.030	0.340 0.280		
6	Crosstube Lug	0.735Inches $\pm$ 0.010	0.745 0.725	reference	
7	Crosstube Lug	1.200Inches $\pm$ 0.030	1.230 1.170	Radius	
8	Crosstube Lug	3.700Inches $\pm$ 0.010	3.710 3.690		
9	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
10	Crosstube Lug	0.625Inches $\pm$ 0.010	0.635 0.615		
11	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
12	Crosstube Lug	0.340Inches $\pm$ 0.030	0.370 0.310	Radius	
13	Crosstube Lug	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
14	Crosstube Lug	0.100Inches $\pm$ 0.010	0.110 0.090		
15	Crosstube Lug	45.000Degrees $\pm$ 0.500	45.500 44.500	angle	
16	Crosstube Lug	1.410Inches $\pm$ 0.030	1.440 1.380	Reference	

Plex 4/3/19 9:23 AM Dart.lajeunesse.marie

SECTION B-B

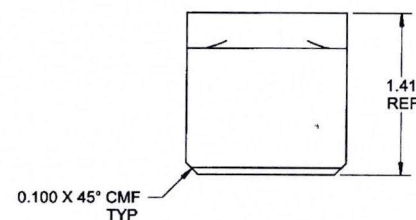


ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-3 X-TUBE LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192861MWS
1901-03



RELEASED

2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO. D3910	REV. E
MFG. APPR.	at	TITLE	SCALE
DE APPR.	142	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043091



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043091

PO Date: 4/3/19

Due Date: 4/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192861	D3910-3P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	4/19/19	15 pcs	0 pcs	15 pcs	\$17.40/pcs	\$261.00
						15 x		APR 23 2019					
2	192787	D4091-1P			Lug : Various STC's As Per Dwg D4091 Rev. A Alodine and Paint as Per QSI 005	Firmed	-	4/26/19	50 pcs	0 pcs	50 pcs	\$17.40/pcs	\$870.00
						50 x		APR 23 2019					
3	192785	D3910-1P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as pe QSI 005	Firmed	-	4/26/19	60 pcs	0 pcs	60 pcs	\$17.40/pcs	\$1,044.00
						60 x		APR 23 2019					
4	192917	D3910-3P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	4/26/19	15 pcs	0 pcs	15 pcs	\$17.40/pcs	\$261.00
Grand Total:													\$2,436.00

DAS
40
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO043091



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 4/4/19 9:38 AM dart.Lussier.Patrick

**METAL TECHNOLOGY INC.**

www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24955
Shipment Date: 04-Apr-2019
Ship Via: Pick up at METEC
Order Number: 3702
Order Date: 04/03/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO043091 ✓
Terms: Net 60 Days

----- Quantity -----									Job
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>	
1	15	15 ✓	0	0	EA	D3910-3P Crosstube Lug alodined and painted as per QSI005	E	3702-01	
2	50	50 ✓	0	0	EA	D4091-1P Lug alodined and painted as per QSI 005	A	3702-02	
3	60	60 ✓	0	0	EA	D3910-1P Crosstube Lug, alodined and painted as per QSI 005	E	3702-03	

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number	
60	D3910-1	Cross Tube Lug	E	B101186	014668-1	43091	DAS 40 9-89
15	D3910-3	Cross Tube Lug	E	B101186	014832-1	43091	
49	D4091-1	Mounting Lug	A	B101186	016012-1	43091	
1	D4091-	Mounting Lug	A	B101186	016012-2	43091	

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, April 4, 2019